

Date: Monday, 11/6/2006 2:41:07 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 29363	
Estimate Number : 12322	
P.O. Number : <u>N/A</u>	Part Number : D3492041
This Issue : 11/6/2006 S.O. No. : <u>N/A</u>	Drawing Number : D3492 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 29044	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 11/28/2006
Checked & Approved By : <u>[Signature]</u>	Qty: <u>82</u> Um: <u>(40)</u> Each
Comment : est rev A 06-03-03 New Issue EC Est Rev:B 06-08-28 As per Rev B JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0656 f(s)/Unit Total : 2.6250 f(s) 5-25'
 6061-T6 Round Bar .625"
 (M6061T6R0625)
 Batch: 102286

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA633 & Dwg D3492
 Dwg Rev: B
 Folio Rev: AA

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr SAD

SAD 06/11/19 (82)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/01/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:41:07 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 29363

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/11/19

(82)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

YD 06/12/07 x 82

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 07 01 03

(82)

9.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Qty Part Number Description

1 NAS1611-010 O-RING

Batch
102535

a.m 07/01/03

(82)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube
A/R 55-O'Ring Lube Batch: 101223

a.m 07/01/03

(82)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 07 01 05

(82)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FP15

FC 07 01 05

(82)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

A 07.01.05

u 07.01.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29363
Description: Plug		Part Number:	D3492-1
Inspection Dwg: D3492 Rev: B		Page 1 of 1	

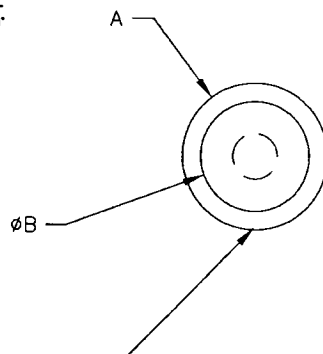
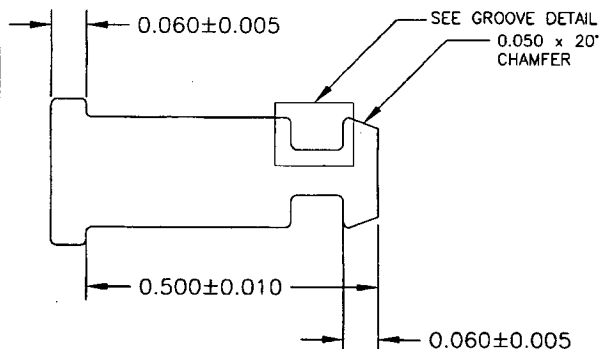
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

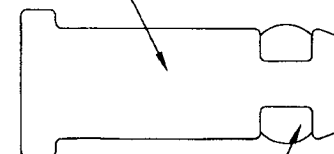
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.065	✓			
0.060	+/-0.005	.060	✓			
Ø0.394	+0.006/-0.001	.394	✓			
Ø0.625	+0.008/-0.001	.625	✓			
0.090	+0.000/-0.002	.089	✓			
0.500	+/-0.010	.503	✓			
0.055	+0.000/-0.002	.054	✓			

Measured by: BG	Audited by: J.G	Prototype Approval:	N/A
Date: 06.11.14	Date: 06/11/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.02	New Issue P/O D3492-041	KJ/JLM	
B	06.10.16	Ø0.625 was Ø0.500	KJ/JLM	BE



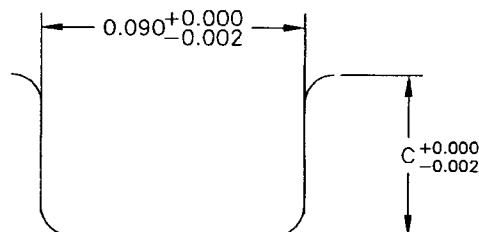
D3492-1/-3/-5/-7 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-005/-007/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

D3492-041/-043/-045 PLUG ASSEMBLY

D3492-1/-3/-5/-7 PLUGS IN ACCORDANCE WITH TABLE 1



GROOVE DETAIL

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500



D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST
(TABLE 2)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D3492-041	PLUG ASSEMBLY
	X			D3492-043	PLUG ASSEMBLY
		X		D3492-045	PLUG ASSEMBLY
			X	D3492-047	PLUG ASSEMBLY
1				D3492-1	PLUG
	1			D3492-3	PLUG
		1		D3492-5	PLUG
			1	D3492-7	PLUG
		1		NAS1611-005	O-RING
			1	NAS1611-007	O-RING
1				NAS1611-010	O-RING
	1			NAS1611-013	O-RING

D3492-1/-3/-5/-7 PLUG NOTES

- MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- BREAK ALL SHARP CORNERS 0.010 MAX

NO 29363
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
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SHOP COPY

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B	06.05.11	ADD -047; UPDATE DIM A, -045
A	06.01.04	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	APPROVED	DRAWING NO. D3492
DATE	TITLE	PLUG
06.05.11		SCALE NTS

RELEASED
06.10.03
REV 4351